

**Work Order ID 79412**

Wednesday, January 25, 2012 1:57:31 PM

**\*79412\****Laefle*

Page 1

Item ID: D4268-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Instrument Panel (212)

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *12-01-25* Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4268	A								
100		0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4268-3)								
<i>224, 040</i>	Dwg Rev: <i>A</i>								<i>(1)</i>
	Prog Rev: <i>A</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

*B12-1-25**B12-1-25*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79412****\*79412\***

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Wednesday, January 25, 2012 1:57:31 PM

Item ID: D4268-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Instrument Panel (212)

Start Date: 1/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

**\*130\***

Small Fab

Small Fab

Memo

1- C'sink holes as per dwg  
2- Bend as per dwg

0.00

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 79412

**\*79412\***

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Wednesday, January 25, 2012 1:57:31 PM

Item ID: D4268-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Instrument Panel (212)  
 Start Date: 1/25/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/27/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160		0.00							
<b>*160*</b>									
SprayPaint	Memo	0.00							
Spray Painting	Prime per QSI 4.2 and as per dwg								
170	QC14- Inspect Spray Paint	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

1 BL 12-1-30

AJ 12-2-1 (1)

12-02-01 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79412****\*79412\***

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Wednesday, January 25, 2012 1:57:31 PM

Item ID: D4268-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Instrument Panel (212)

Start Date: 1/25/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

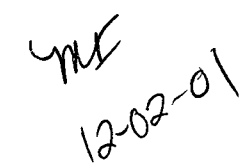
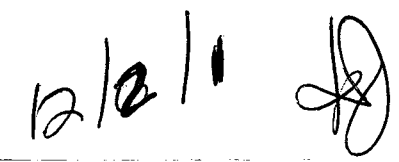
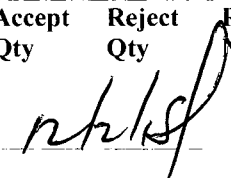
Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, January 25, 2012 1:57:30 PM

Page 1

Work Order ID: 79412

Parent Item: D4268-3

Start Date: 1/25/2012

Required Date: 1/27/2012

Parent Item Name: Instrument Panel (212)

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	134.3184	0.0744	0.0783158			

2024-T3 .040 sheet

812-1-26

Location

Loc Qty

Loc Code

MAT022

134.318421

117684

26.318421

120196

108

120196

①

# Dart Aerospace Ltd

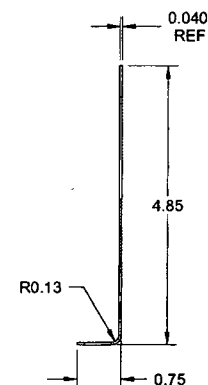
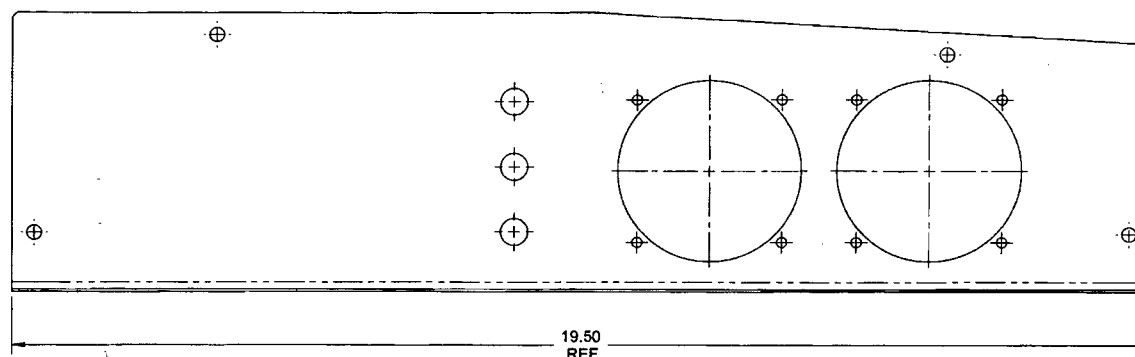
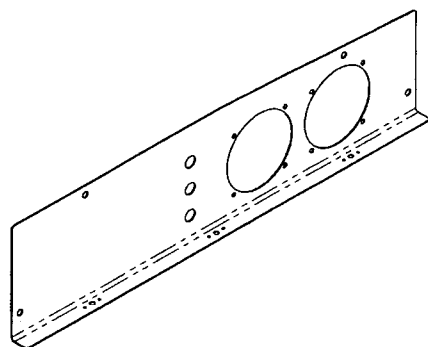
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4268-3 INSTRUMENT PANEL (212/412)**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

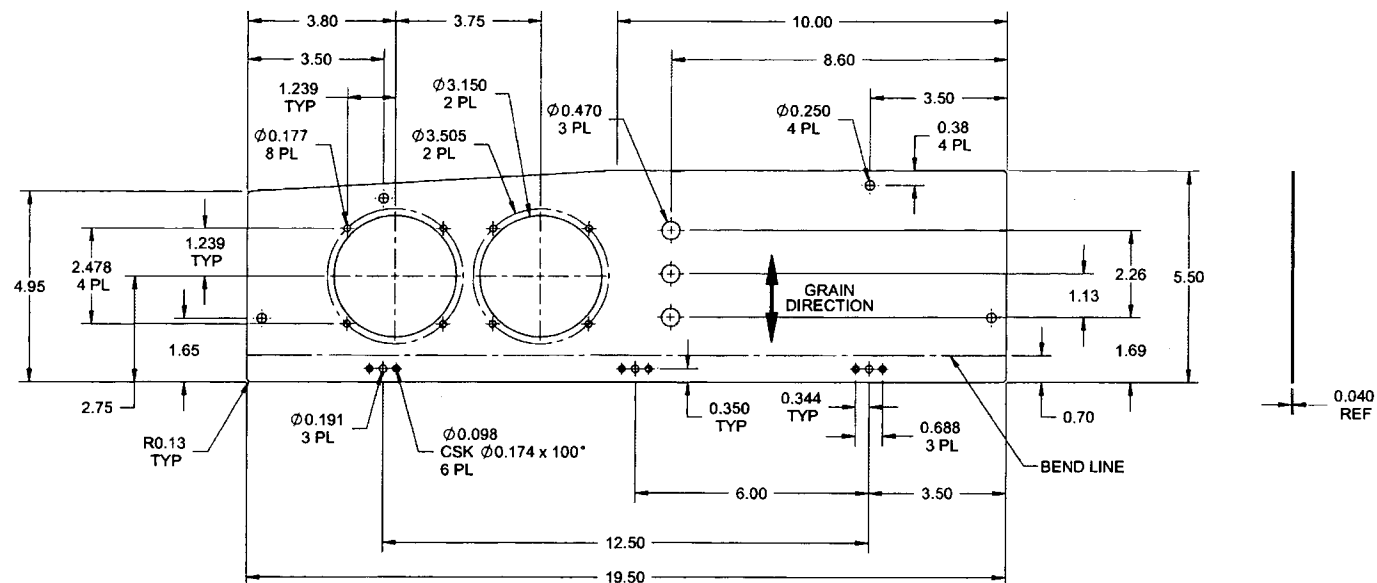
**NOTES:**

- 1) MATERIAL: MAKE FROM D4268-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4268</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE <b>VRD PARTS</b>	SHEET 5 OF 12
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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**RELEASED**  
2011-04-06  
*[Signature]*

# 79412







**D4268-3F FLAT PATTERN**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

# 79412

**RELEASED**  
2011-04-06

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4268</b>	SHEET 6 OF 12
APPROVED		TITLE	SCALE
DE APPR.		<b>VRD PARTS</b>	NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 29412
<b>Description:</b> Instrument Panel		<b>Part Number:</b> D4268-3
<b>Inspection Dwg:</b> D4268	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.098	2			
Ø0.177	+0.005/-0.001	.177	2			
Ø0.191	+0.005/-0.001	.191	2			
Ø0.250	+0.005/-0.001	.249	2			
Ø0.470	+0.006/-0.001	.470	2			
Ø3.150	+0.012/-0.001	3.152	2			
Ø3.505	+0.012/-0.001	3.510	2			
4.95	+/-0.030	4.957	2			
2.478	+/-0.010	2.488	2			
1.239	+/-0.010	1.239	2			
1.65	+/-0.030	1.651	2			
2.75	+/-0.030	2.752	2			
19.50	+/-0.030	19.50	2			
12.50	+/-0.030	12.50	2			
6.00	+/-0.030	6.00	2			
3.50	+/-0.030	3.50	2			
0.350	+/-0.010	.352	2			
0.344	+/-0.010	.343	2			
0.688	+/-0.010	.690	2			
1.69	+/-0.030	1.684	2			
1.13	+/-0.030	1.127	2			
2.26	+/-0.030	2.257	2			
5.50	+/-0.030	5.507	2			
0.38	+/-0.030	.379	2			
3.50	+/-0.030	3.503	2			
8.60	+/-0.030	8.60	2			
10.00	+/-0.030	10.00	2			
3.80	+/-0.030	3.86	2			
3.75	+/-0.030	3.76	2			
3.50	+/-0.030	3.501	2			
1.239	+/-0.010	1.239				
0.040	+/-0.010	.038				

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Preliminary Approval:</b>
<b>Date:</b> 12-1-26	<b>Date:</b> 17/01/27	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	P/O D4268-043	KJ